

# Work Order ID 86258

Monday, June 25, 2012 2:00:14 PM

**\*86258\***

Page 1

Item ID: D3702-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fwd Doubler

Stop

**\*NS2\***

Start Date: 6/25/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 12-06-25 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3702	Rev B					(8)			
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3702 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2- Deburr if necessary								
6061 .080									
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B12-6-26

B12-6-26

8/12/06/27

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3702-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Doubler

Start Date: 6/25/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Deburr if necessary

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150

**\*150\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

8 7/12/12

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Item ID: D3702-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Fwd Doubler

Stop **\*NS2\***

Start Date: 6/25/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 196

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

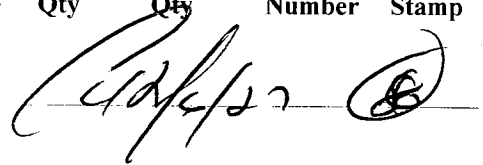
**\*180\***

QC

Memo

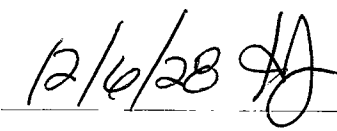
0.00

Quality Control



8

17/06/27 B

ME  
12-06-27



# Picklist Print

Monday, June 25, 2012 2:00:14 PM

Page 1

Work Order ID: 86258

Parent Item: D3702-1

Parent Item Name: Fwd Doubler

Start Date: 6/25/2012

Required Date: 6/29/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No				sf	322.0443		4.08		6, 13 12-6-26	

Location

Loc Qty

Loc Code

MAT021

322.044316

117285

0.124316

119766

39.6

120096

268.62

121193

13.7

120096

(8)

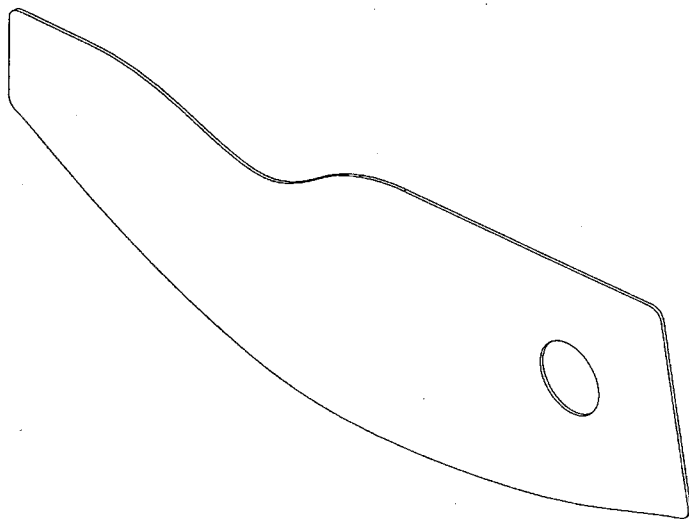
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3702-1 FORWARD DOUBLER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3702-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3702-1 = 0.39 lbs
- 8) MANUFACTURE PART FROM "D3702-1.DXF" FILE

*86258*

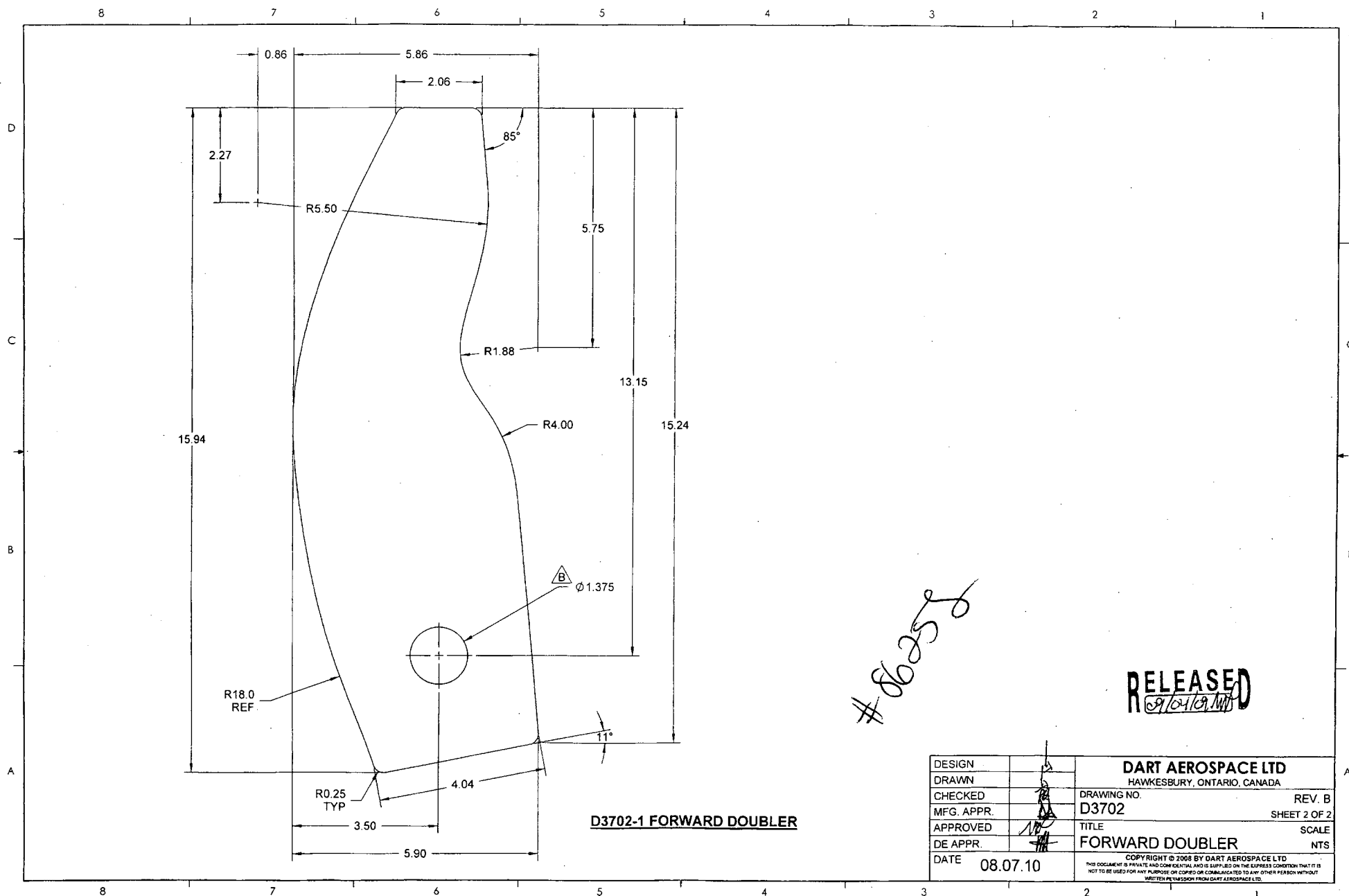
**RELEASED**  
*09/21/09*

B	Ø 1.375 WAS Ø 1.25 (ZIN B5-2) REASON: HOLE ENLARGED FOR INSTALLATION OF GROMMET	MB	08.07.10
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.10		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3702</b>	REV. B SHEET 1 OF 2
TITLE <b>FORWARD DOUBLER</b>	SCALE NTS
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#86258

RELEASED  
9/04/09

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3702</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>FORWARD DOUBLER</b>	NTS
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